



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-012

Job Sheet 167568-B

Rush

Part No: D350-636-012

Job Qty: 1 ea

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/2/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Heli-Fix Maintenance Inc (CHF101)

252 Edouard Drouin St Jerome, QC, J7Y 4X5 Canada ph:(450) 712-3955

Note: European warehouse

Ship Via:

000016

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs		11/23/17	0.00	4.36	Skidtubes		
120	QC	1 pcs		11/23/17	0.00	0.00	QC10		
130	QC	1 pcs		11/23/17	0.00	0.00	QC5		
140	HandFinish	1 pcs		11/23/17	0.00	0.91	HandFinish1		
150	QC	1 pcs		11/23/17	0.00	0.00	QC7		
160	Skidtubes	1 pcs		11/23/17	0.00	4.36	Skidtubes		
170	QC	1 pcs		11/23/17	0.00	0.00	QC10		
180	QC	1 pcs		11/23/17	0.00	0.00	QC5		
190	HandFinish	1 pcs		11/23/17	0.00	0.91	HandFinish2		
200	SprayPaint	1 pcs		11/23/17	0.00	0.69	Spray Paint		
210	QC	1 pcs		11/23/17	0.00	0.00	QC14		
230	HandFinish	1 pcs		11/24/17	0.00	0.91	HandFinish4		
240	QC	1 pcs		11/24/17	0.00	0.00	QC5		
250	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging1		
260	QC	1 pcs		11/24/17	0.00	0.00	QC4		
265	DC	1 pcs		11/24/17	0.00	0.00	DC		
270	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3		
280	QC21-FG	1 Ea		11/24/17	0.00	0.00	QC21		

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150.8

Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

*M/L BE
M138673*

160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2

Prime 134670

white paint: 138714

JAN 24 2016

SOB1708 RH

F9072 sold 7.8°

DART
AEROSPACE
S031708

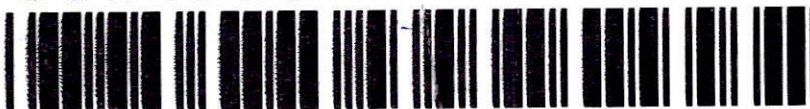
Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com



**Skidtube RH, Std Wearplates, DART (Apical)
Cylindrical/Aerazur Float Comp.**

PART NO: D350-636-012

Revision:

Operation: Start up Operation

Change No: CHG007

Mfg Date: 01/12/18

Job No: 167568-B

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 5-Coat all exposed fasteners with "LPS Procyon" batch: M133690

265 - record fwd angle: ~~89.90~~ Photocopy blue file and type labels per PPP D350-636-012 CHG 007

270 - Package as per PPP D350-636-012 → 89.90

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-3-BENT-RH <u>5030330</u>	1	0	0	0
	D2744 <u>5003318</u>	1	20	0	0
160-Skidtubes	D2739 <u>145489</u>	1	15	0	0
	D2743 <u>8160400</u>	8	145	0	0
	D3490-1 <u>F165397</u>	4	33	0	0
	D3490-3 <u>F165398</u>	4	20	0	0
230-HandFinish <u>F1135998-2</u>	ALS4-1032-225	38	879	0	0
	AN3C5A <u>5019396</u>	34	412	0	0
	AN3C6A <u>F1137361-1</u>	4	80	0	0
	AN6C44A <u>F1137055-1</u>	4	251	0	0
	AN8C35A <u>F1137203</u>	1	97	0	0
	D2745 <u>5000390</u>	8	92	0	0
	D3488-042 <u>F165333</u>	1	5	0	0
	D3492-1 <u>5025647</u>	8	59	0	0
	D3492-3 <u>F165369</u>	8	101	0	0
	D3535-25 <u>5032628</u>	1	11	0	0
	D3536-25 <u>5031897</u>	1	13	0	0
	D3537-1 <u>5031939</u>	3	94	0	0
	D3631-1 <u>5008168</u>	8	4	0	0
	D3791-1 <u>F161928</u>	1	9	0	0
	D3793-1 <u>F165211</u>	1	9	0	0
	D3793-3 <u>M165566-14</u>	1	10	0	0
	D3794-1 <u>M163497-123</u>	1	8	0	0
	D3794-3 <u>F165210</u>	1	11	0	0
	MS21043-6 <u>5016883</u>	4	66	0	0
	MS21083C8 <u>F1138238-1</u>	1	31	0	0
	NAS1149C0332R <u>5027570</u>	38	4,240	0	0
	NAS1149C0832R <u>F11355360</u>	1	118	0	0
	NAS1515H3LF <u>M137361-2</u>	4	222	0	0
	NAS1611-010 <u>F1137587-3</u>	8	123	0	0
	NAS1611-013 <u>5022099</u>	8	117	0	0
250-Packaging <u>5034972</u>	AN8C21A <u>5034916</u>	2	235	0	0
<u>5034917</u>	D2741 <u>5034914</u>	1	70	0	0
<u>5034978</u>	D3493-1 <u>5034914</u>	2	38	0	0
<u>5034983</u>	D3532-1 <u>5034921</u>	2	11	0	0
<u>5034985</u>	MS21083C8 <u>5034923</u>	2	31	0	0
<u>5034986</u>	NAS1149D0863J <u>5034924</u>	2	205	0	0

Part Specifications

Specifications could not be found.

Plex 11/2/17 3:15 PM dart.Michaud-Febrille.Victoria

800040

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C4A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

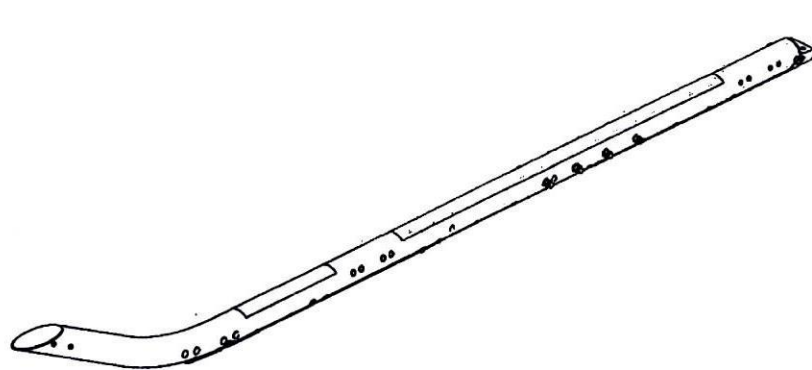
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G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5-8/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H4L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
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MFG. APPR.			
APPROVED			
DE APPR.			
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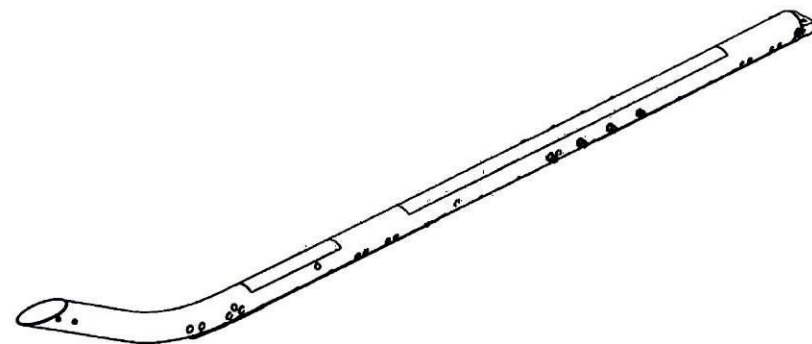
DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D2750
TITLE
350 SKIDTUBE ASSEMBLY
REV. G
SHEET 1 OF 11
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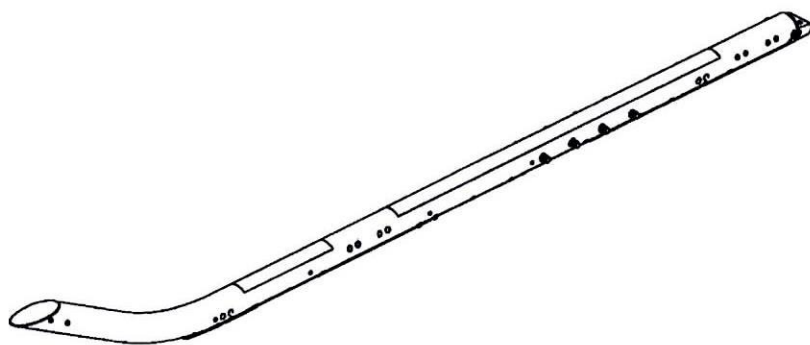
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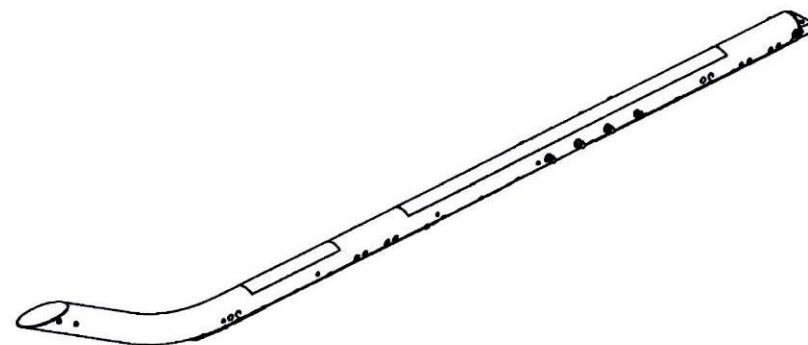
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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D2750-043 350 SKIDTUBE ASSEMBLY, LH

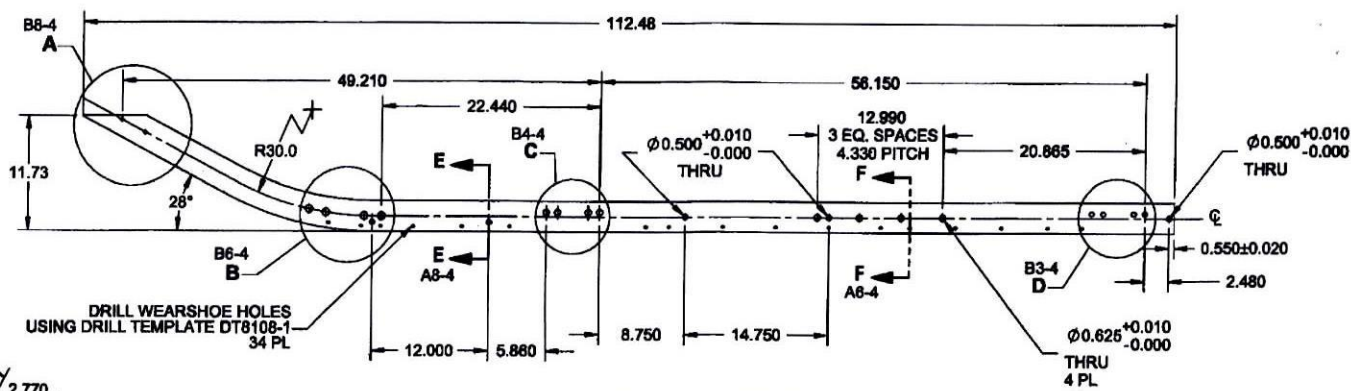


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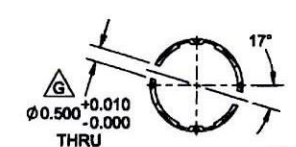
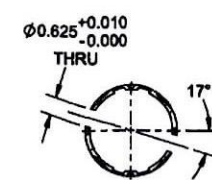
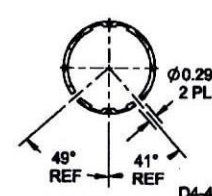
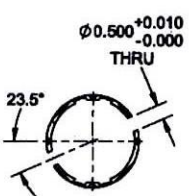
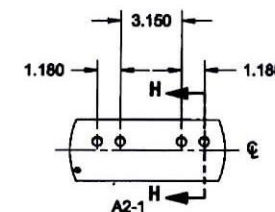
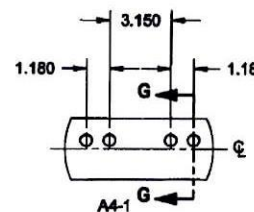
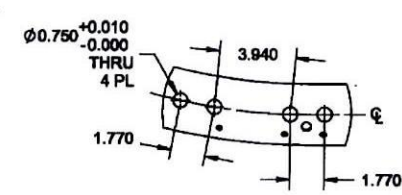
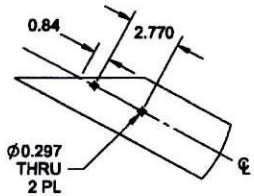
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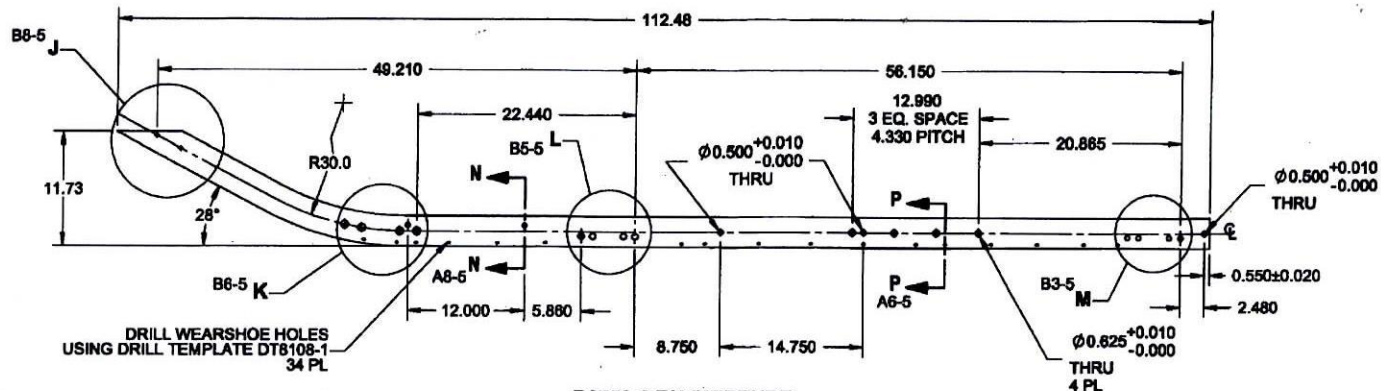
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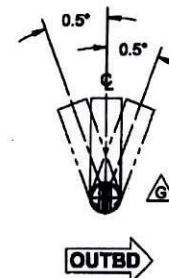
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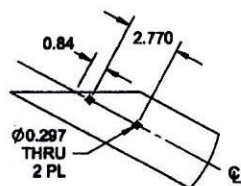
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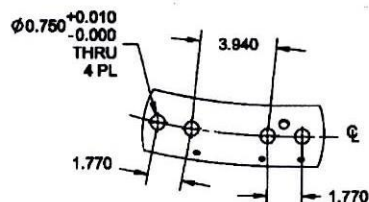
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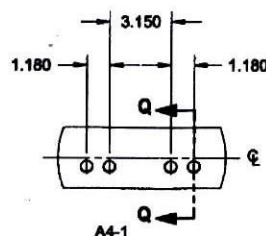
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



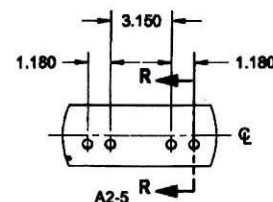
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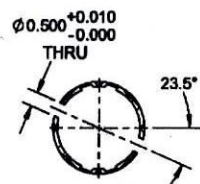
DETAIL K
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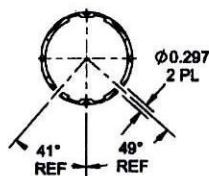
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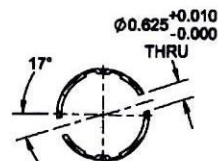
DETAIL M
SCALE 2X



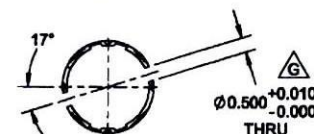
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

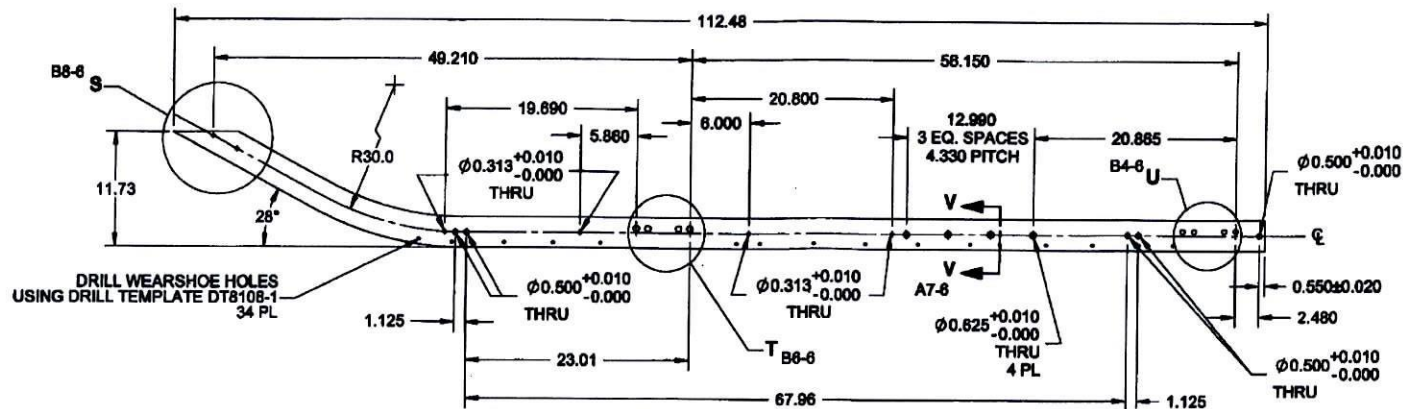


SECTION R-R
SCALE 3X, 4 PL

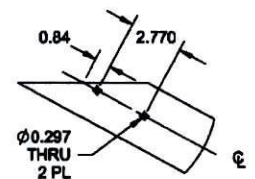
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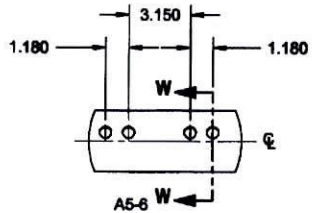
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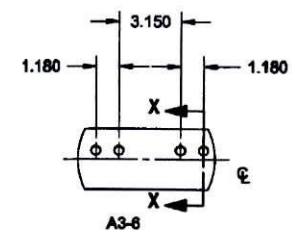
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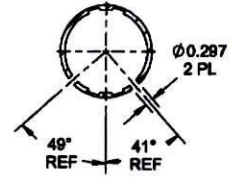
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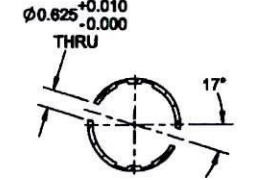
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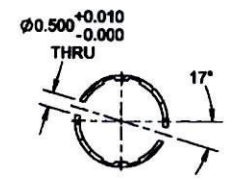
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



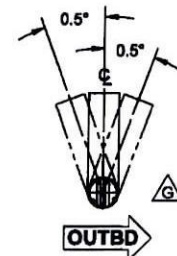
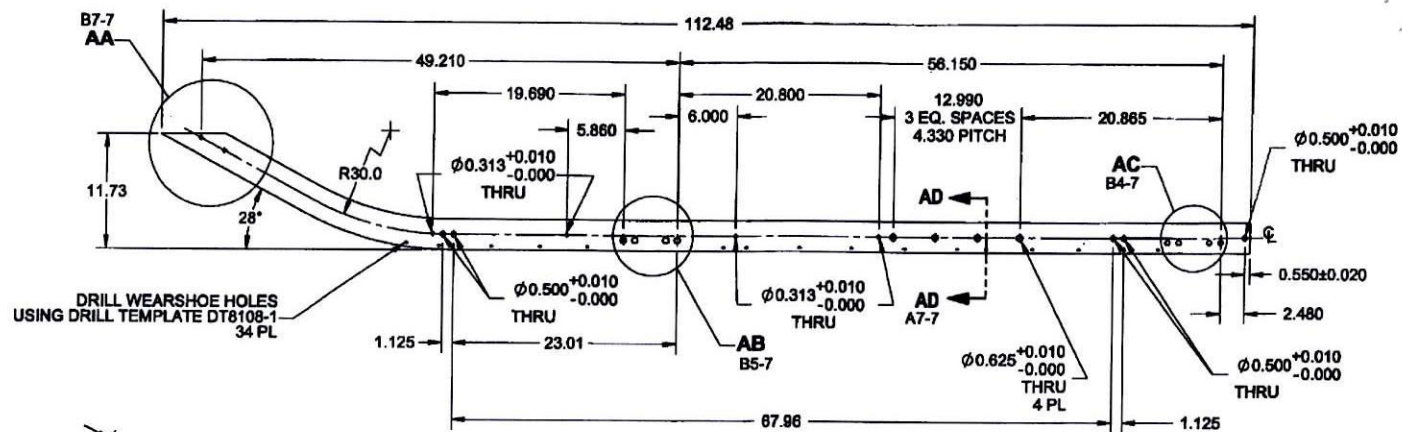
SECTION X-X
SCALE 3X, 4 PL

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MFG. APPR.		SHEET 8 OF 11	
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.		DATE 13.07.11	

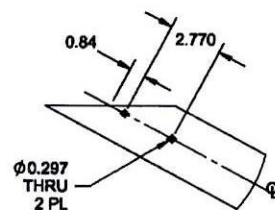
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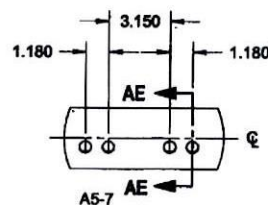


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

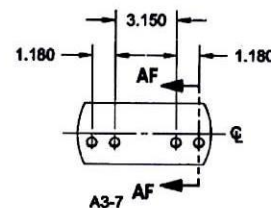
D2750-4 RH SKIDTUBE



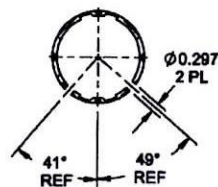
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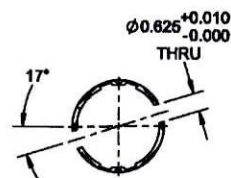
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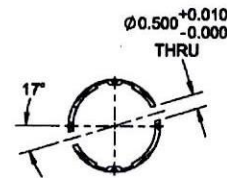
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SECTION AD-AD
SCALE 3X, 17 PL



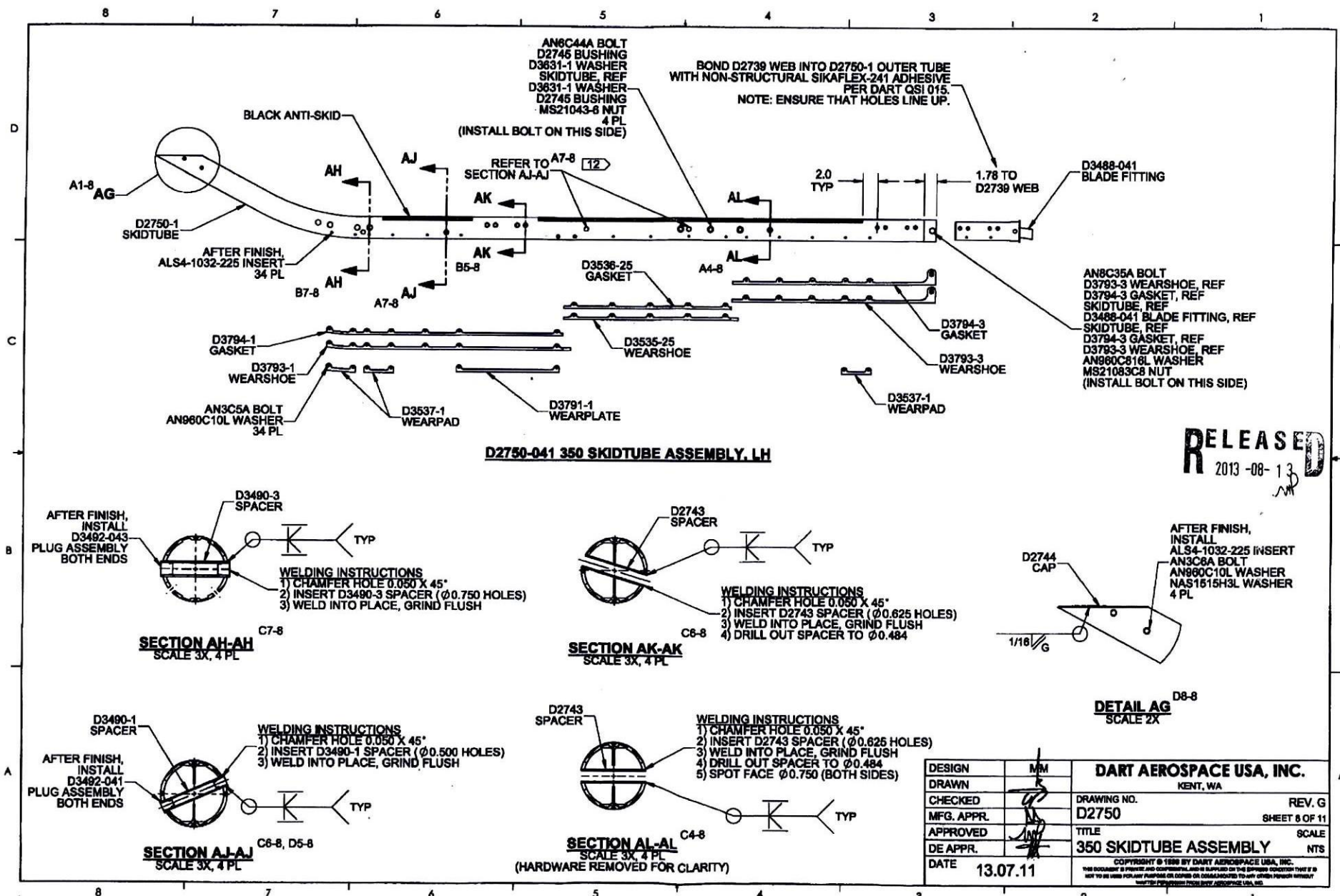
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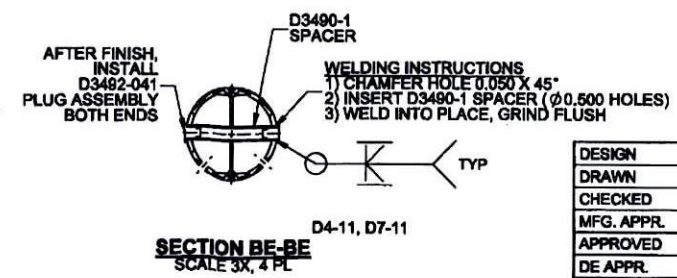
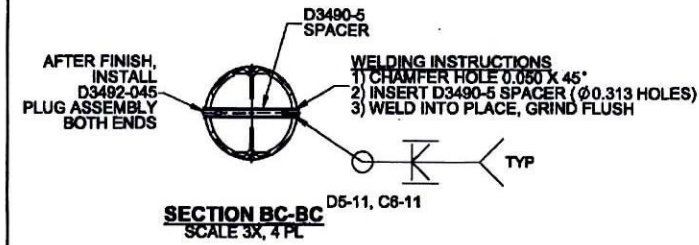
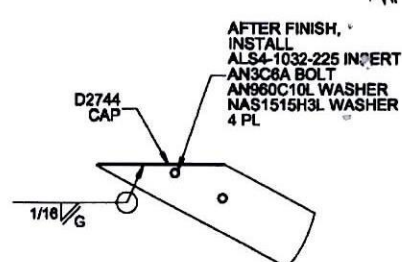
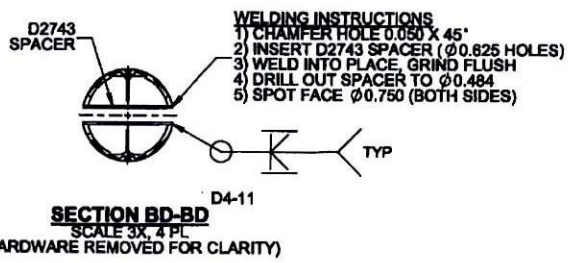
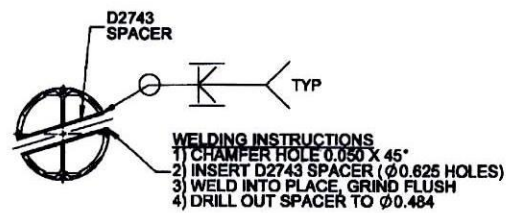
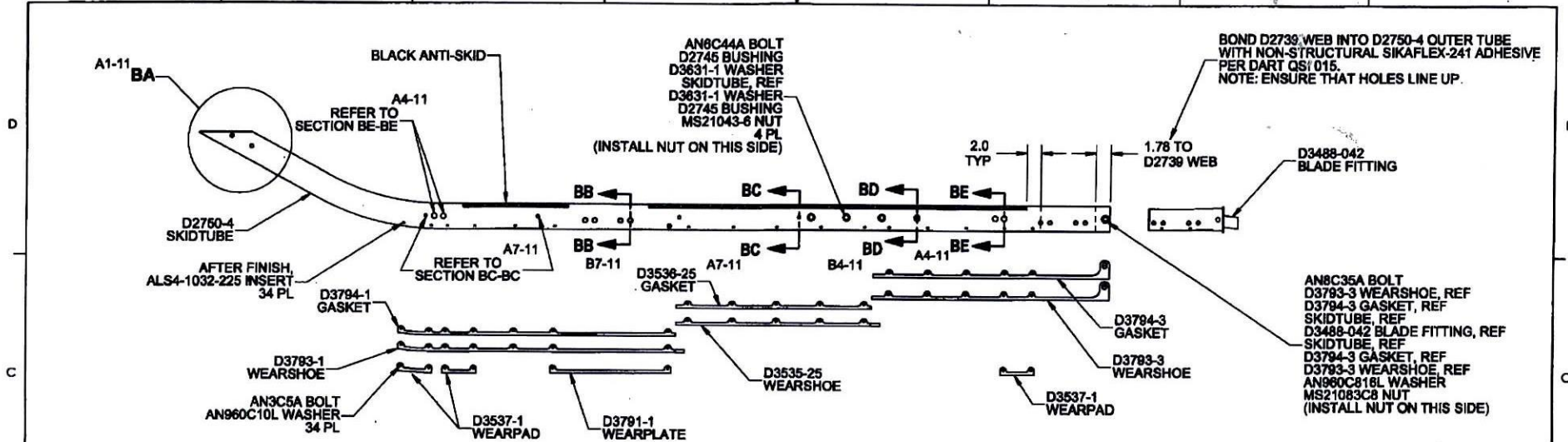
SECTION AF-AF
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MFG. APPR.		D2750	SHEET 7 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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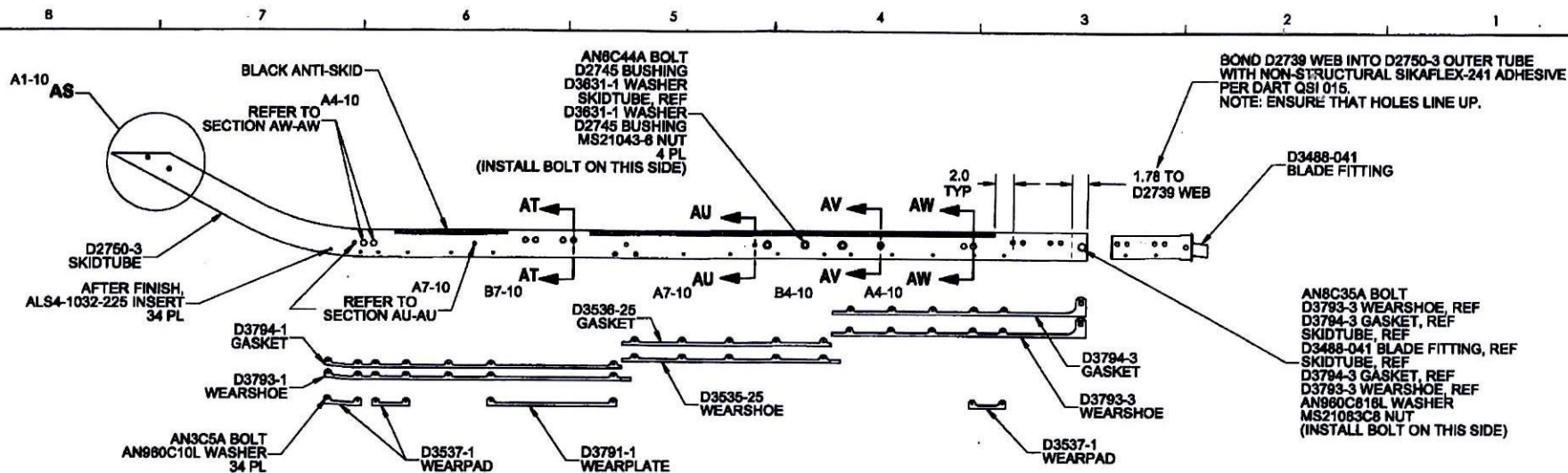


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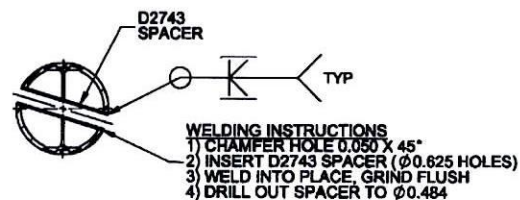
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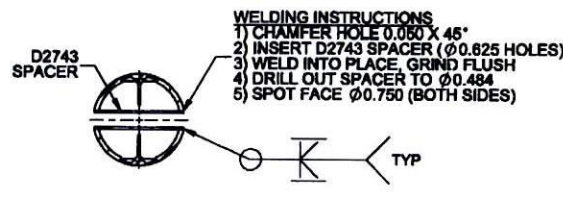


D2750-043 350 SKIDTUBE ASSEMBLY, LH

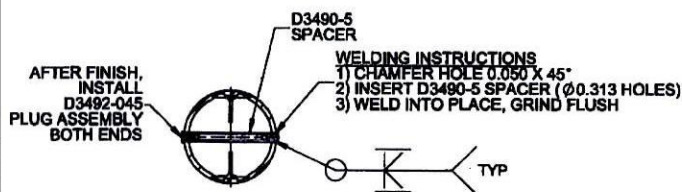
RELEASE
2013-08-13



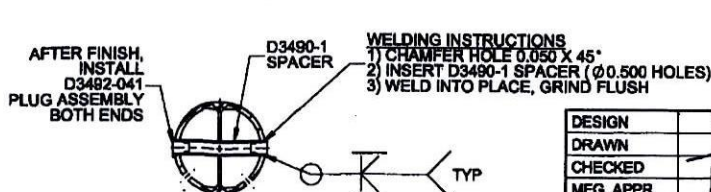
SECTION AT-AT
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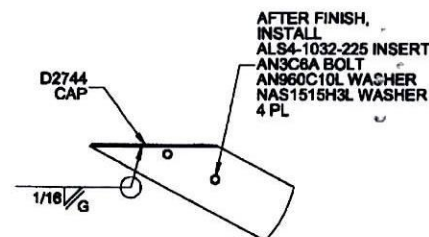
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

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Change Record

PAGE 1 OF 1

Part Number: D350-636-011/-011GB/-012/-012GB

Description: SKIDTUBE STD LH/RH, FLOAT COMPATIBLE

[illegible]